

Date: Thursday, 12/15/2005 3:55:23 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 25248		
Estimate Number	: 10980		
P.O. Number	: NIA	Part Number	: D2808
This Issue	: 12/15/2005 S.O. No. : NIA	Drawing Number	: D2808 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: NIA Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: NIA	Material	: NIA
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 12/22/2005 Qty: 30 Um: Each
Checked & Approved By	: <u>SEE ABOVE DATE & USER</u>		
Comment	: Est Rev:D 02.03.07 Now turned in house NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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Comment: Qty.: 0.0557 f(s)/Unit Total : 1.6695 f(s)
 6061-T6 Round Bar .625"
 (M6061T6R0625)
 Batch: M 18 740

ml 06/01/12 30

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA205(Mesure D3387 Bracket .507" Dia for Proper press-fit)

2-Deburr

ml 06/01/13 30

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/01/13 30

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL 06.01.13 30

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
 Chemical Conversion Coat as per QSI 005 4.1

SAD 06:01:18 30

5.1

Powder Coat Gloss White as per PART QSI 005 4.3

DL 06/02/19 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/02/21

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SPACER

Job Number: 25248

Part Number: D2808

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C206102120

(30)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 388

C206102120

(30)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUR 06/02/21

(30)

D 061021/21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

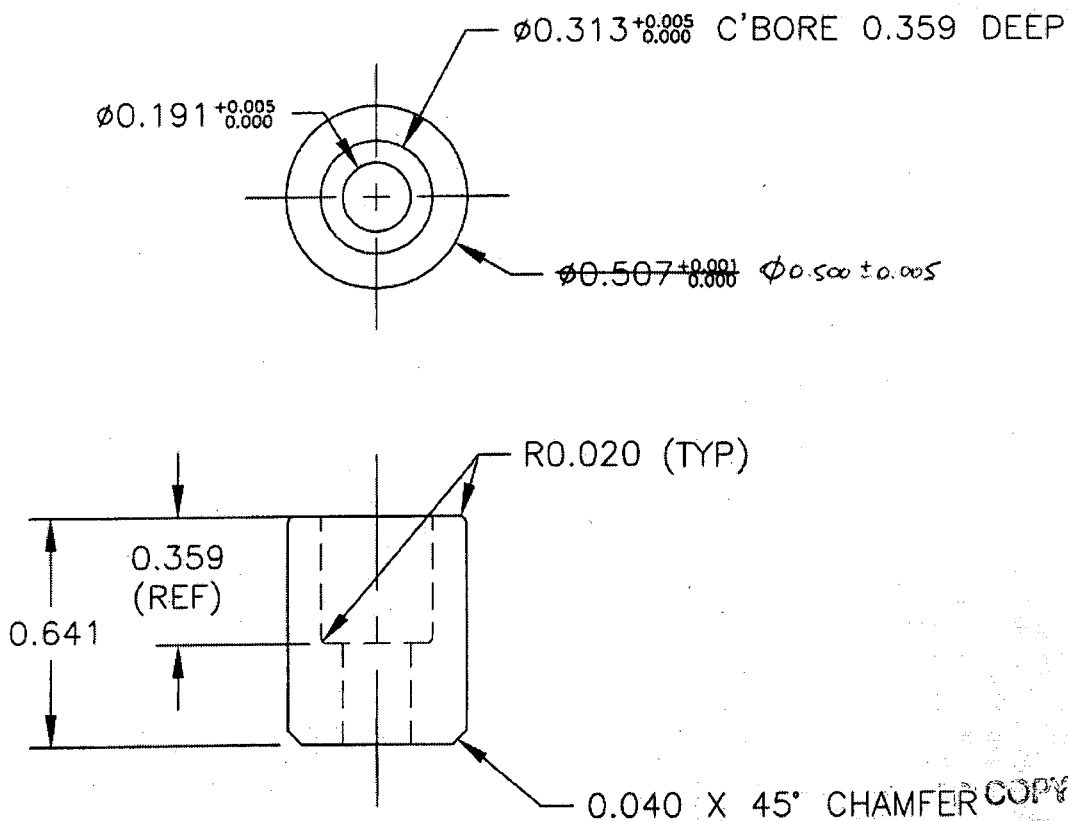
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2808	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	01.04.26	ADD POWDER COAT ; $\phi 0.500$ WAS $\phi 0.507$	

RELEASED
00.11.13 #

RETURN TO
ENGINEERING
CONTROLLED COPY
NOT TO BE LENT
WITHOUT NOTICE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020
MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7)
OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

WORK ORDER
NO. 25248

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